

24

Date: Wednesday, 5/16/2007 1:40:37 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG
Job Number : 32403
Estimate Number : 10271
P.O. Number : *PIA*
This Issue : 5/16/2007 S.O. No. : *PIA*
Prsht Rev. : NC
First Issue : *PIA* Type : SMALL /MED FAB
Previous Run : 30384
Written By : *PIA*
Checked & Approved By : *PIA*
Comment : Est C 00.05.19 Added inspect level 8 EC
Est Rev:D Now on Waterjet 06-06-14 JLM

Part Number : D2561
Drawing Number : D2561 REV B
Project Number : N/A
Drawing Revision : B
Material : *PIA*
Due Date : 6/10/2007 Qty: 48 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0250X06000 6061-T6 Bar .25" x 6.0"

Comment: Qty.: 0.3850 f(s)/Unit Total : 18.4817 f(s) ~~18.4817~~

Material: 6061-T6, or 5052-H34 6.00" x 0.25" Thick

Batch: *M100351**M103433**ml 07/06/16*

(48)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2561

Dwg Rev: *B*Prog Rev: *B**ml 07/06/16*

(48)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

*ml 07/06/16*

(48)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En 07/06/16

(48)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr, no sharp edges

SN 07/06/16

(48)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: R Date: 10/10/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2561

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *W423*

PK-07-06-26

48

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(48)

Comment: FINAL INSPECTION/W/O RELEASE

SD 0718126

Job Completion



W 0718126

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

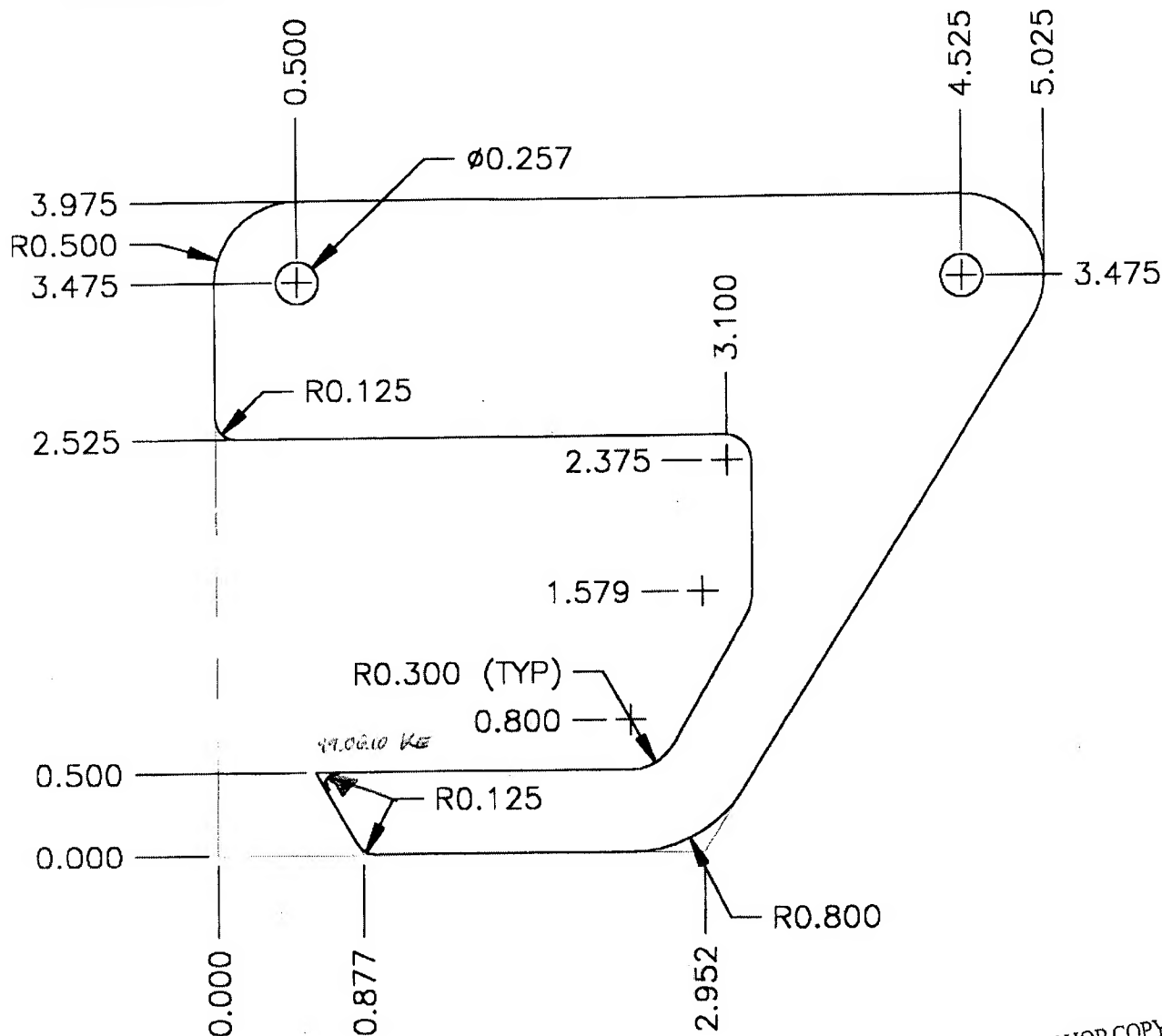
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED	APPROVED	D2561	SHEET 1 OF 1
DATE		TITLE	SCALE
96.04.26		LUG PLATE	1:1

RELEASED
96 05 06



MATERIAL: 6061-T6 0.25 THICK
OR 6063-T6 0.25 THICK
OR 5052-H34 0.25 THICK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32403